

Tuesday, 09/12/2008 9:38:56 AM
User: Julie Dawson

Process Sheet

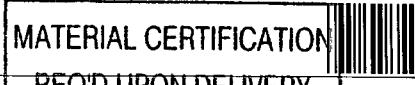
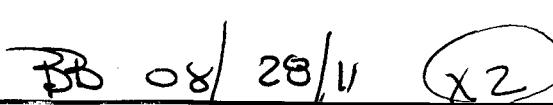
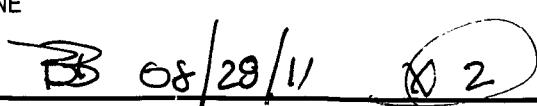
Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HAT BIN 206 A/B	
Job Number	: 43951		Part Number	: D38241	
Estimate Number	: 13592		Drawing Number	: D38241 PROTOTYPE	
P.O. Number	:		Project Number	: IN0002	
This Issue	: 09/12/2008 S.O. No. :		Drawing Revision	: PROTOTYPE	
Prsht Rev.	: NC		Material	: MKYD6185S080P362015	
First Issue	: / / Type : R&D THERMOFORMING		Due Date	: 16/12/2008 Qty: 1 Um: Each	
Previous Run	: 42074				
Written By	:				
Checked & Approved By	: JUD 08.12.09				
Comment	: Est. A New Issue 08/09/17 DL				

Additional Product

PROTOTYPE

(P) 08.12.09

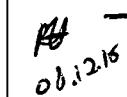
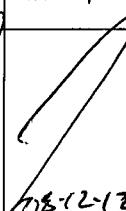
UPDATED BY 08.12.22

Seq. #:	Machine Or Operation:	Description:	
1.0	MKYD6185S080P362015	6185 KYDEX .080"	 
		Comment: Qty.: 11.3747 sf(s)/Unit Total : 11.3747 sf(s) 6185 Kydex .080"	REQ'D UPON DELIVERY M 109703 BB 08/12/15
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
		Comment: HAND FINISHING THERMOFORMING	
	1) Machine set up		BB 08/28/11 X 2
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
		Comment: HAND FINISHING THERMOFORMING	
	1) Cut sheet to required blank size		BB 08/28/11 X 2
4.0	THERMOFORMING	THERMOFORMING MACHINE	
		Comment: THERMOFORMING MACHINE	
	Thermoform as per Dwg. D3824-1 and folio (FTA 9405 Prototype) using tool DT 9405		
	Dwg. Rev. <u>A</u>	Folio Rev. <u>D</u>	
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
	Visually inspect for proper formation of each part		
			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/15	6.	Scrap. While Applying reinforcement doubler on the back side of the part, the glue reacted with the materials. Le Page contact cement was used, and the Kydex WAS very thin in the deepest corners. P.C. un-approved adhesive, and not compatible with the material.	 JOSIMUL	- Scrap & destroy. Qtry 1 - Bonding agent is yet to be determined.	 PA 08.12.15	 JOSIMUL	 08-12-15	 JOSIMUL
		# prototype *						

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: HAT BIN 206 A/B	
Job Number: 43951	Part Number: D38241	
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC8	SECOND CHECK  J 0612.12(6)
Comment: SECOND CHECK		
7.0	HAND FINISH TH	HAND FINISHING THERMOFORMING 
Comment: HAND FINISHING THERMOFORMING		
1) Trim to Finished Dimensions	08/01/12 	
8.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
Check dimensions to ensure conformity to drawing tolerances.	08/01/12 	
9.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP	08.12.12 AF 	
10.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location:	FOR ENGINEERING USE ONLY NOT FOR STOCK # of 08.12.22	
11.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE	08.12.16 Prototype W of 12.24 with deviation per for attached	
Job Completion		

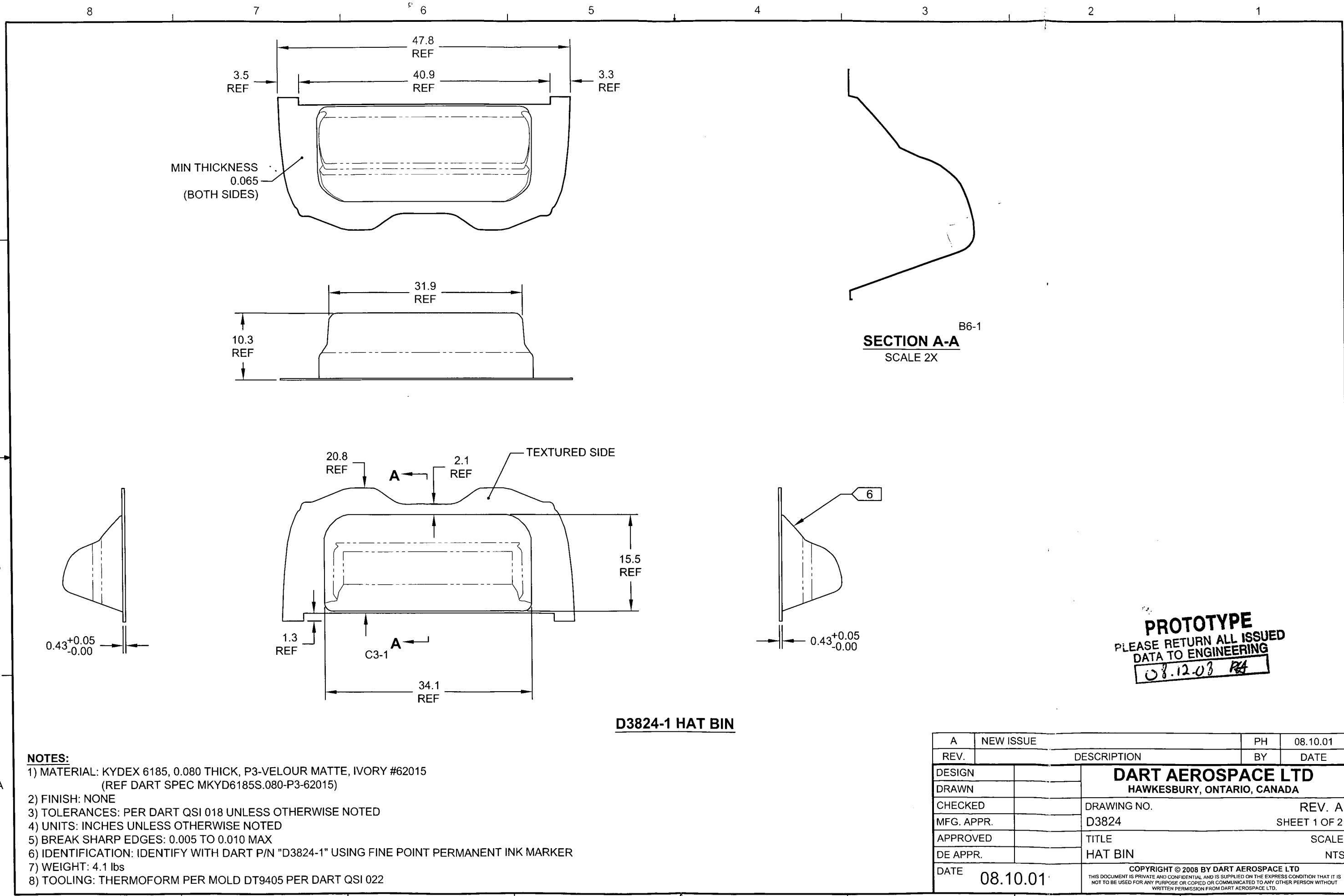
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD	Work Order:	43951
Description: Hat Bin 206 A/B / Prototype	Part Number:	03824-1
Inspection Dwg: D3824 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

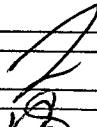
Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____ "				
Shape Definition	/			
Texture Retention	/			
Material imperfections such as bumps, cracks, voids, scratching	/			

Measured by: 

Date: 08.12.12

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.065	Min	0.063	/	/		
10.3 (Ref)	± 0.100	10.25	/			
31.5 (Ref)	± 0.100	31.9125	/			
34.1 (Ref)	± 0.100	34	/			
2.1 (Ref)	± 0.100	2.125	/			
20.8 (Ref)	± 0.100	20.8	/			
1.3 (Ref)	± 0.100	1.25	/			
40.9 (Ref)	± 0.100	40.9375	/			
47.8 (Ref)	± 0.100	47.8125	/			
0.43	$+0.05/-0.0$	0.46	/			

Measured by: 

Date: 08.12.12

Audited by: 

Date: 08.12.12

Prototype Approval: 

Date: 08.12.12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

Receiving Report

Date:

8/10/04

Batch No:

M109703

Supplier:

SA BRC

Dart P/O:

7280

Packing Slip: Yes No
Invoice: Yes No
Receipt: Cash Cr

Release Note Attached: Yes No N/A
Waybill Attached: Yes No N/A
Shipment Complete: Yes No N/A
QC6 Inspection 08/10/04 N/A
Work Order N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 JL

Admin: _____

Location: _____

سabic
sabic

SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM #: 1

QUANTITY: 51

51 *84287*

S
08/01/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS
OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE
PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND
LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER

